

Work Order ID 72325

Friday, July 22, 2011 11:24:38 AM

Page 1

Item ID: D4306-044

Accept

Revision ID:

Item Name: Rib Assembly, RH

Start Date: 7/22/2011 Start Qty: 2.00

Required Date: 7/29/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4306

C

100

Weld per dwg A/R S.S. rod Batch: M118366 0.00

Large Fab

Memo

0.00

Large Fab

1- Cut tube 52"
2- Bend tube with manuel pipe bender as per DT9567
*** Make line at 10.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
3- Trim access tube material to finish size and cut notch as per dwg D4306-4
4- Drill and chamfer holes as per dwg D4306-4 using DT9710
5- weld bushing as per dwg D4306
6- grind welds flush

SAD 12-05-08

110

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Siderlog

@

2x Ø 12-05-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D4306-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly, RH

Start Date: 7/22/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Signature

Signature

2/0 6/12.05.09

12/5/9

MC 12/05/09

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Picklist Print

Friday, July 22, 2011 11:24:43 AM

Page 1

Work Order ID: 72325

Parent Item: D4306-044

Parent Item Name: Rib Assembly, RH



Start Date: 7/22/2011

Required Date: 7/29/2011


Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1  Bushing		Manufactured	No			100	Each	137.0000	4	8			
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Location	Loc Qty	Loc Code
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WA	135	
69202	135	
WA005	2	
66489	2	

779213 - 8

M304TS0.750W.049  304 SQ Tube .75x.75x.049W		Purchased	No			100	f	285.0645	4.166	8.770526			
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Location	Loc Qty	Loc Code
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MAT018	108.325209	
117690	4.372109	
117775	103.9531	
MAT034	7.5904	
117337	7.5904	
WA	169.14894	
118184	169.14894	

M21439 8.7766

7/12/05-08

SAD 12-05-08

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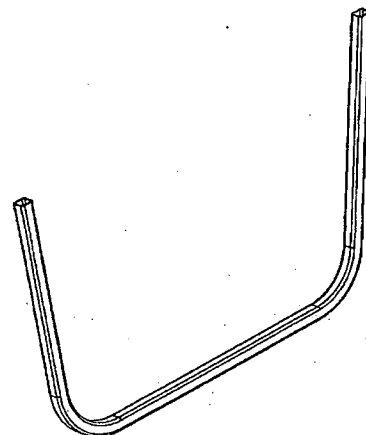
NOTE: Date & initial all entries

SHOP COPY

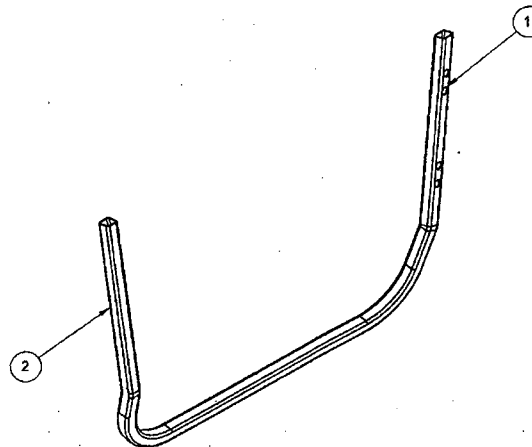
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WITHOUT NOTICE
WORK ORDER
NO. 72325

11-07-22

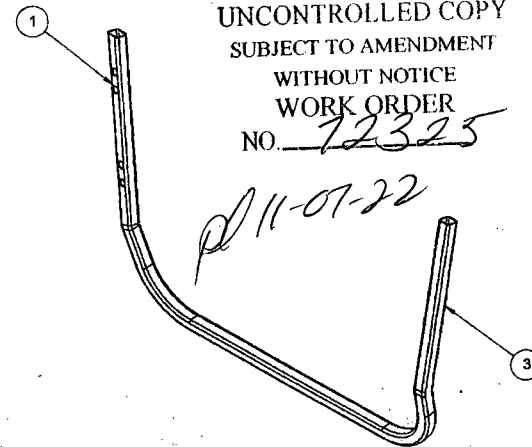
ITEM	QTY -043	QTY -044	QTY -045	P/N	DESCRIPTION
	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



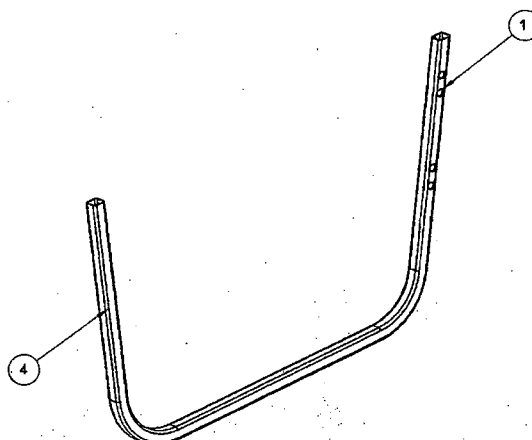
D4306-1 RIB



D4306-043 RIB ASSY, LH



D4306-044 RIB ASSY, RH



D4306-045 RIB ASSY

RELEASED
2011-03-19

C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4/5); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-8, C2-8); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-6); ADDED 4.60" REF DIM ON D4306-043/044 (B6-3, B3-5)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.09		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4306 TITLE RIB REV. C SHEET 1 OF 8 SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED BY THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

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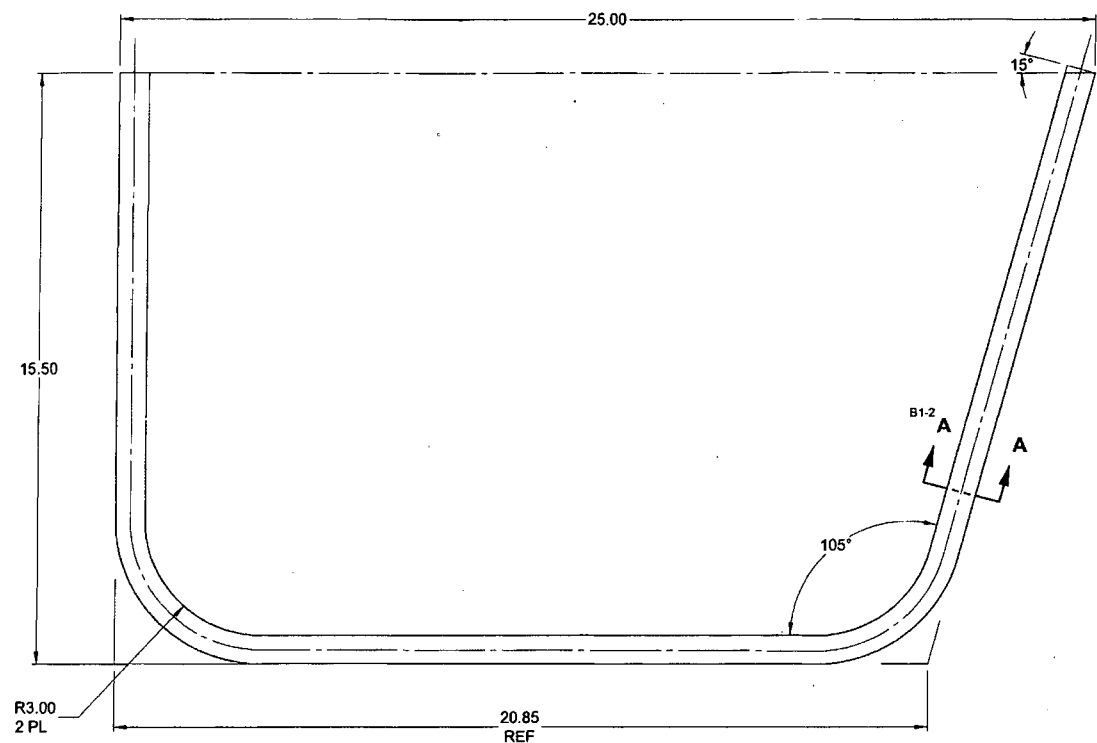
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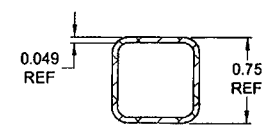
C

B

A



72325



SECTION A-A B4-2

8 D4306-1 RIB

RELEASED
2011-02-24
WMD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

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8 7 6 5 4 3 2 1

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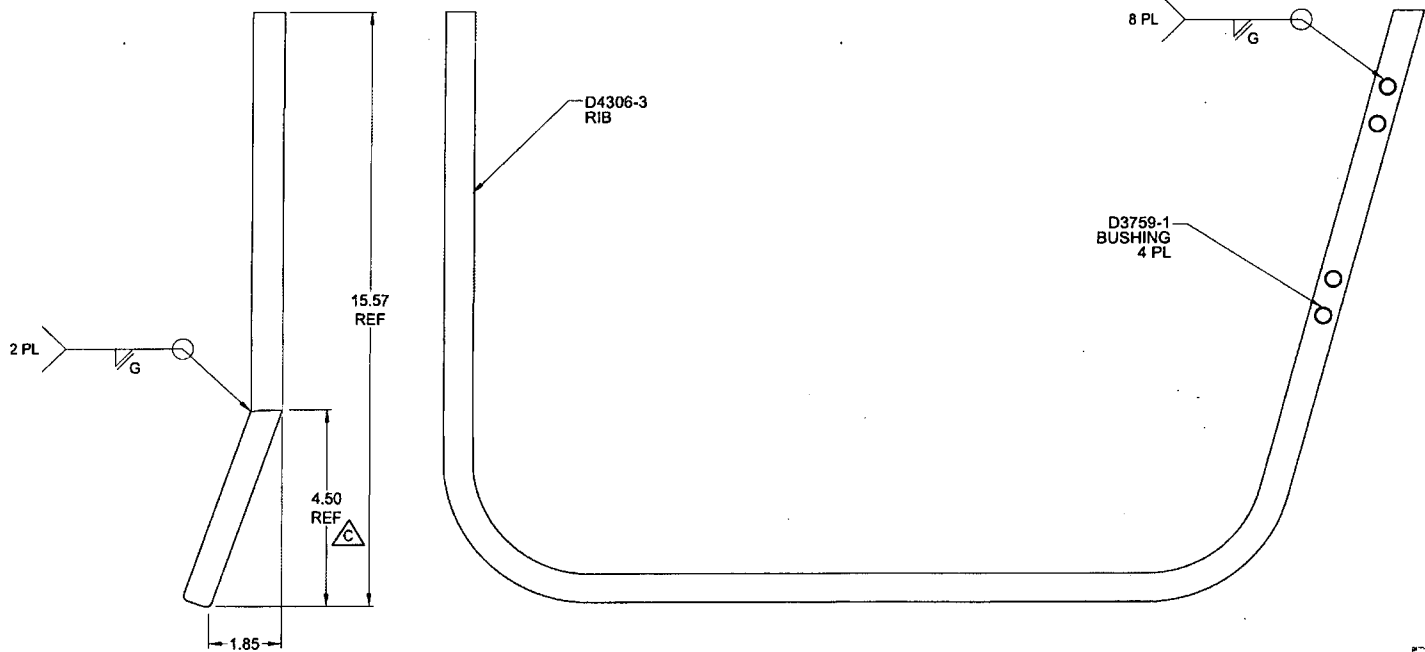
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72325



D4306-043 RIB ASSY, LH

RELEASED
2011-02-24
WJ

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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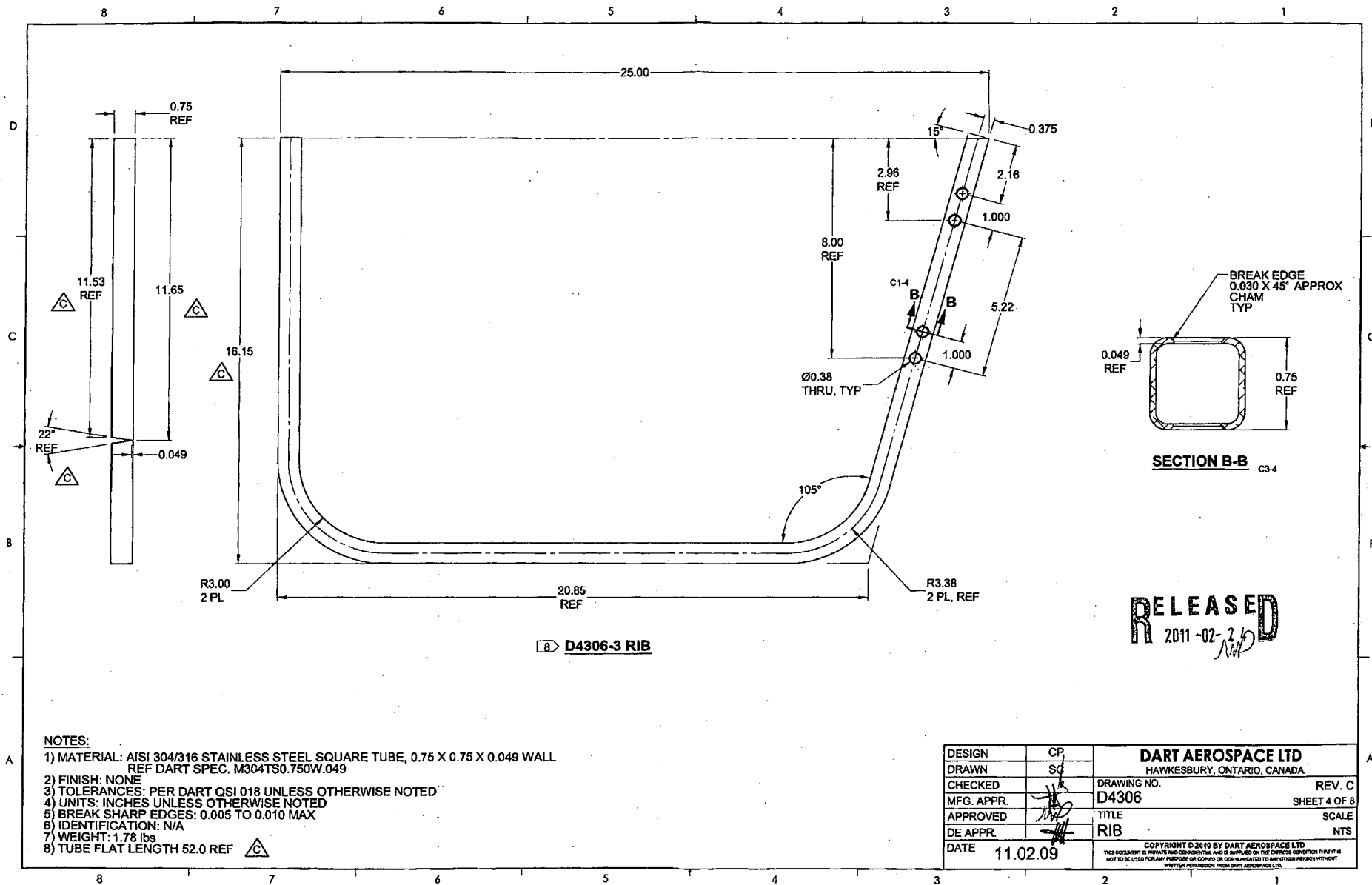
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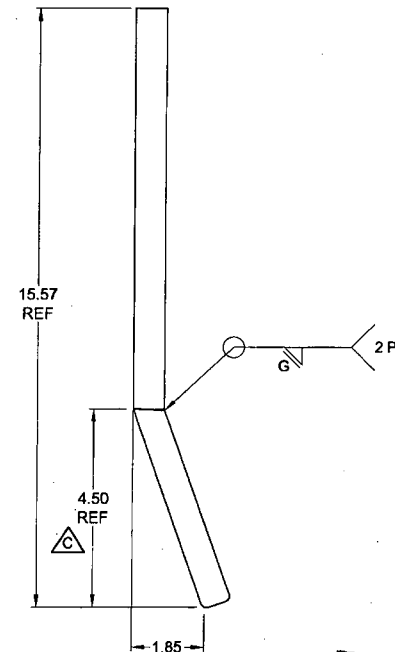
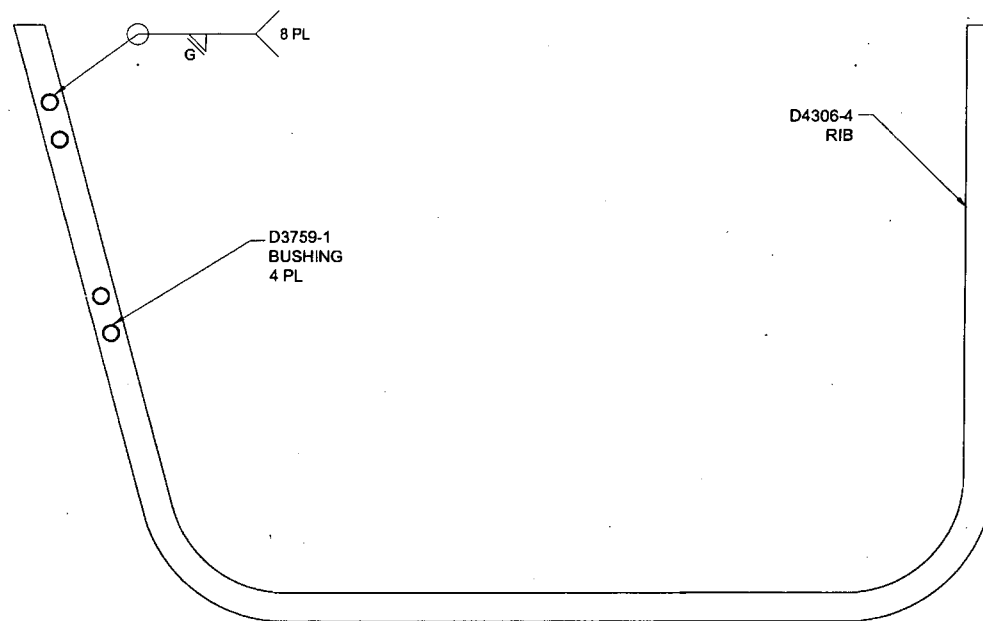
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NOTE: Date & initial all entries

12325



D4306-044 RIB ASSY, RH

RELEASED
2011-02-24
WMP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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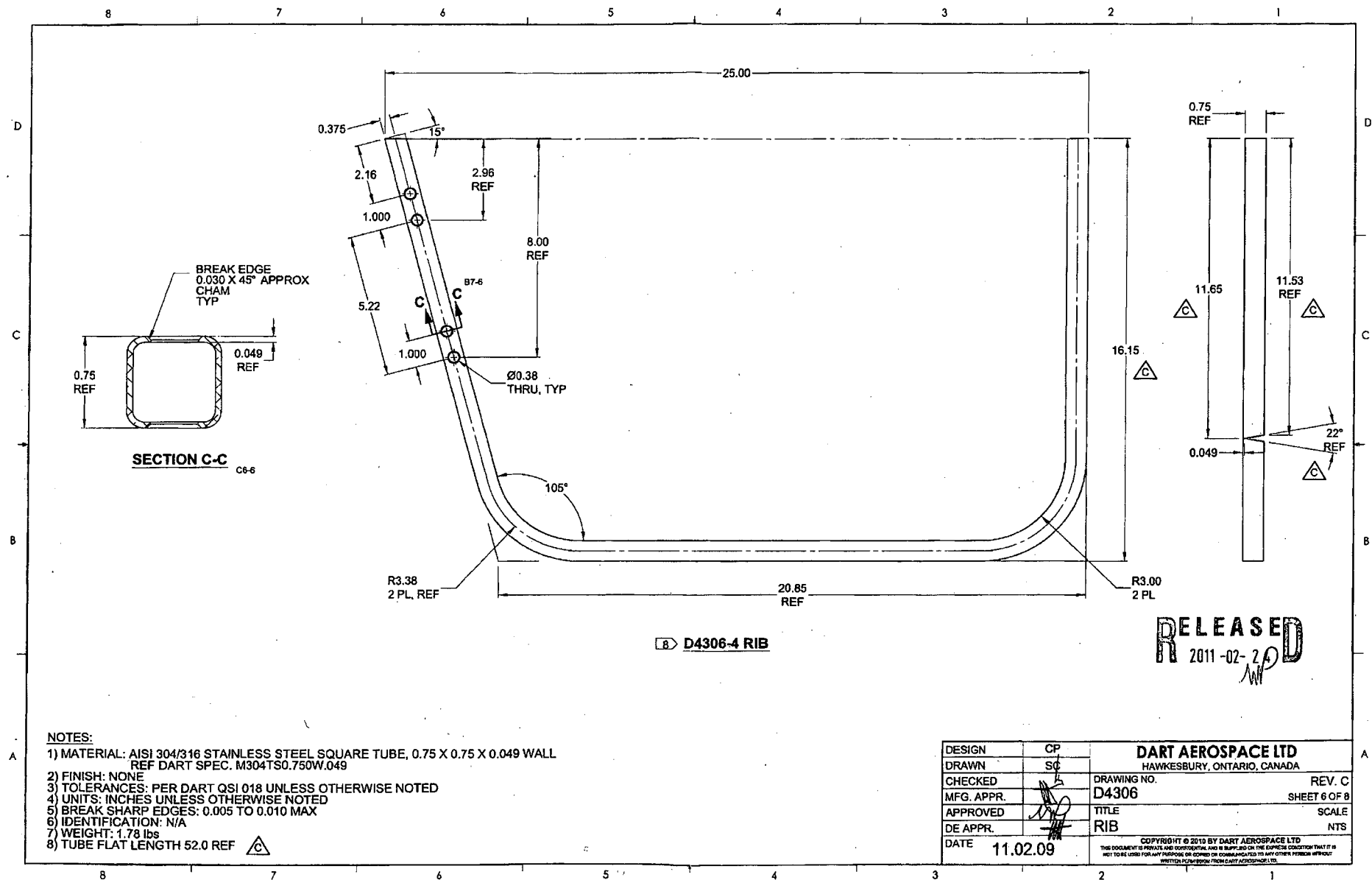
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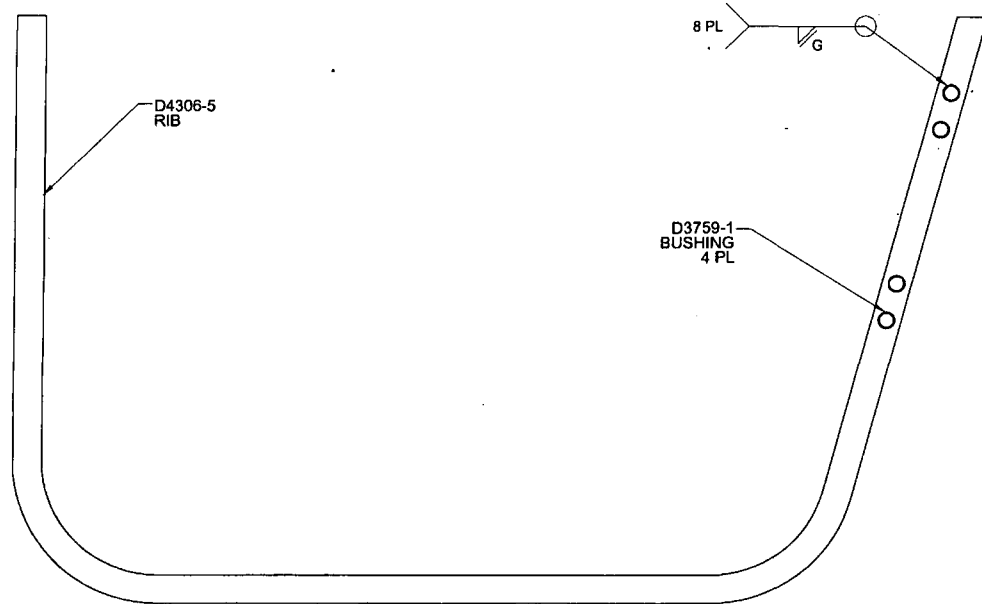
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D4306-045 RIB ASSY

RELEASED
2011-02-24
MB

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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